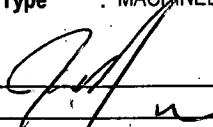
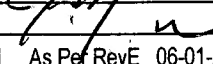


Date: Tuesday, 1/2/2007 1:28:51 PM
 User: Chantal Lavoie







Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 30096		
Estimate Number	: 10533		
P.O. Number	: N/A	Part Number	: D2573
This Issue	: 1/2/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2573 REV E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29662	Drawing Revision	: E
Written By	: 	Material	: N/A
Checked & Approved By	: 	Due Date	: 1/9/2007
Comment	: Est: 1 As Per RevE 06-01-27 JLM	Qty:	12
		Um:	8 Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	7075-T7351 8.25X7.75X2.5
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>B25355</u> x 12 Ep 07/01/07		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>830096</u> Double check by: <u>J.F.</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. Ep / J.F. 07/01/18 (12)		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 Ep / J.F. 07/01/18 (12)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☒ DQA: ☒ Date: ☒ 07/01/22

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 1/2/2007 1:28:51 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 30096

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En/J.F. 07/01/18 (12)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.01.18

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

JS/YC

07.01.18 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SR/a.m

07/01/19 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 7/01/22 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

51471

PC 7/01/22 (12)

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/22 (12)

Job Completion



CL 07/01/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order: 300%
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.749	1.748	1.747		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.749	1.748	1.747		
E	7.990	8.010		8.000	8.002	8.002	8.003		
F	0.490	0.510		0.496	0.502	0.501	0.499		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.507	0.507	0.504	0.504		
J	1.174	1.184		1.177	1.177	1.178	1.176		
K	0.558	0.578		0.567	0.566	0.568	0.570		
L	1.174	1.184		1.177	1.177	1.178	1.176		
M	1.365	1.375		1.367	1.369	1.369	1.369		
N	2.495	2.505		2.497	2.498	2.499	2.501		
O	4.119	4.129		4.122	4.122	4.123	4.120		
P	0.115	0.135		0.127	0.127	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.255	0.250	0.249	0.250		
S	0.115	0.135		0.124	0.125	0.125	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.245	0.239	0.240	0.237		
W	0.115	0.135		0.126	0.125	0.125	0.126		
X	0.308	0.313		0.310	0.310	0.309	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.368	0.366	0.366	0.366		
AA	0.470	0.530		0.506	0.500	0.500	0.506		
AB	0.615	0.635		0.629	0.629	0.628	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.253	0.251	0.251	0.246		
AE	1.500	1.520		1.509	1.510	1.509	1.511		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.258	0.246	0.246	0.245		
AI	2.000	2.020		2.000	2.000	2.000	2.001		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by: E.P.
Date: 07/01/13

Audited by: J.F.
Date: 07/01/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 30096
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.749	1.747	1.750		
C	3.495	3.505		3.498	3.499	3.499	3.500		
D	1.745	1.755		1.750	1.749	1.747	1.750		
E	7.990	8.010		8.003	8.003	8.004	8.003		
F	0.490	0.510		0.499	0.498	0.498	0.497		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.378	0.378	0.378	0.378		
I	0.490	0.510		0.504	0.504	0.506	0.505		
J	1.174	1.184		1.176	1.177	1.177	1.177		
K	0.558	0.578		0.567	0.568	0.567	0.567		
L	1.174	1.184		1.176	1.177	1.177	1.177		
M	1.365	1.375		1.366	1.371	1.371	1.371		
N	2.495	2.505		2.498	2.498	2.498	2.498		
O	4.119	4.129		4.123	4.120	4.120	4.120		
P	0.115	0.135		0.127	0.126	0.126	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.250	0.250	0.250		
S	0.115	0.135		0.126	0.121	0.126	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.236	0.238	0.237		
W	0.115	0.135		0.122	0.124	0.122	0.123		
X	0.308	0.313		0.310	0.309	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.369	0.367	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.629	0.629	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.248	0.245	0.244		
AE	1.500	1.520		1.513	1.512	1.511	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.248	0.245	0.248		
AI	2.000	2.020		2.002	2.002	2.001	2.002		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by: <u>En</u>	Audited by: <u>J.F.</u>
Date: <u>07/10/13</u>	Date: <u>07/10/15</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 30096
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.749	1.750	1.754"		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.749	1.750	1.754		
E	7.990	8.010		8.005	8.004	8.004	8.002		
F	0.490	0.510		0.499	0.499	0.498	.501		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.378	0.378	0.378	0.378		
I	0.490	0.510		0.502	0.504	0.501	.505"		
J	1.174	1.184		1.177	1.177	1.177	1.177"		
K	0.558	0.578		0.567	0.568	0.567	.570"		
L	1.174	1.184		1.177	1.177	1.177	1.177"		
M	1.365	1.375		1.369	1.370	1.365	1.373		
N	2.495	2.505		2.500	2.500	2.500	2.500"		
O	4.119	4.129		4.120	4.120	4.120	4.126		
P	0.115	0.135		0.126	0.126	0.127	.128"		
Q	0.115	0.135		0.135	0.135	0.135	.135"		
R	0.240	0.260		0.250	0.251	0.250	.250"		
S	0.115	0.135		0.125	0.126	0.124	.127"		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.238	0.238	.244		
W	0.115	0.135		0.123	0.124	0.124	.126		
X	0.308	0.313		0.316	0.310	0.310	.311"		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.366	0.366	.372"		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.626	0.627	.633		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.247	0.245	.249		
AE	1.500	1.520		1.511	1.511	1.510	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.251	0.249	.253		
AI	2.000	2.020		2.000	2.000	2.000	2.001		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

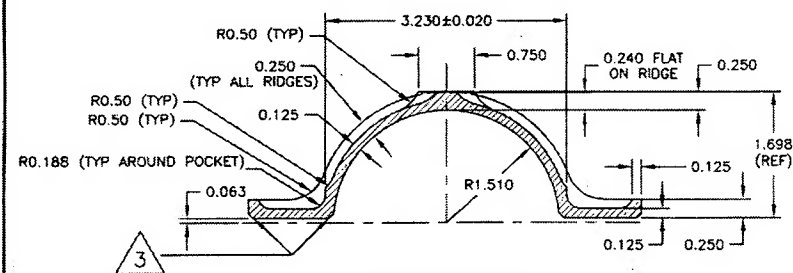
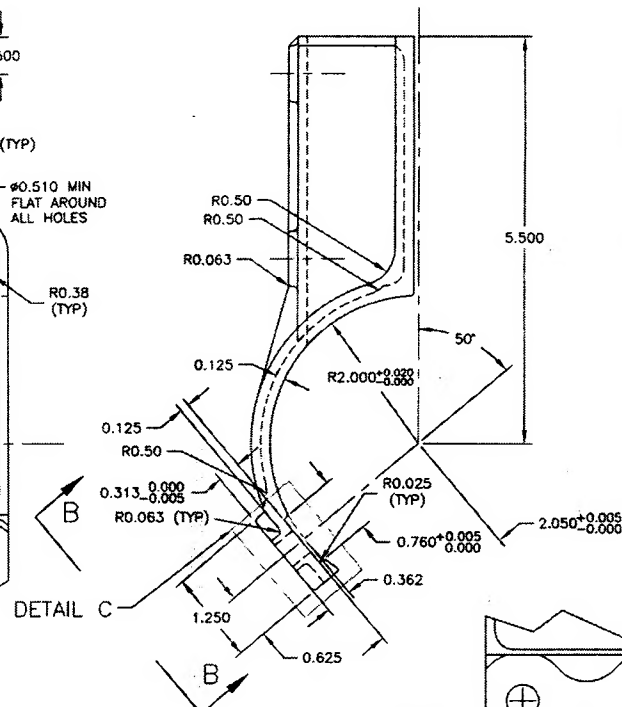
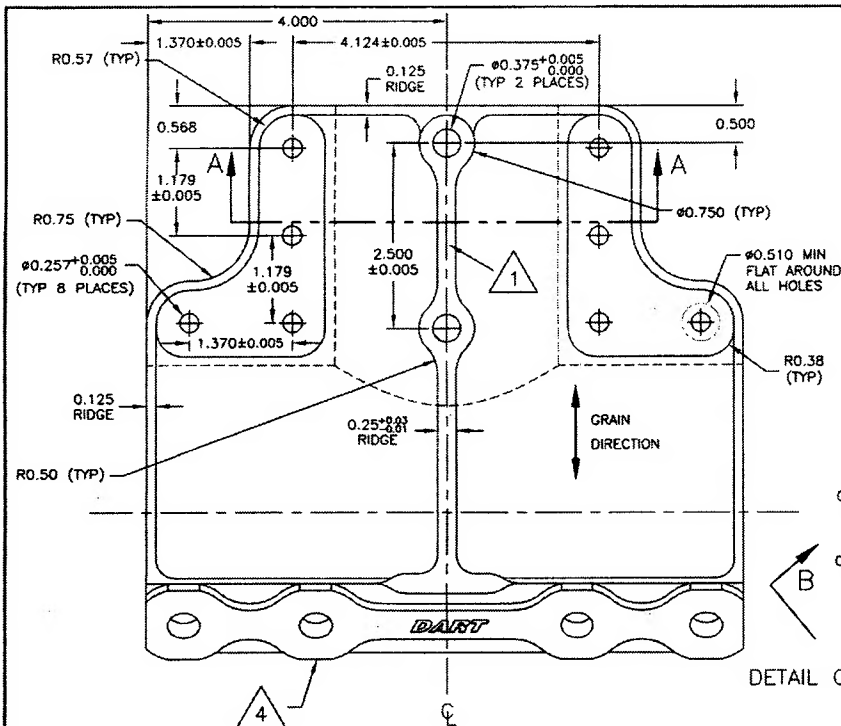
Measured by: E.A. / J.F.
Date: 07/01/16

Audited by: SA
Date: 01.01.16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06



SECTION A-A

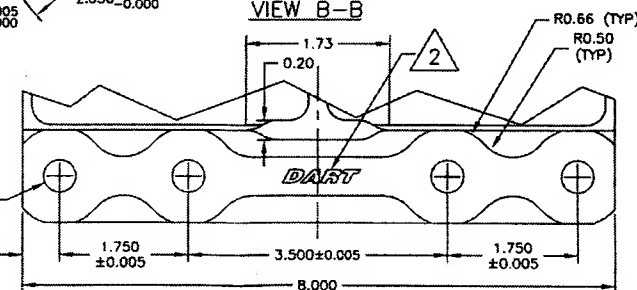
DETAIL C
SCALE 4:3

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C) E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD.
CHECKED	#	APPROVED	#	DRAWING NO.	02573
DATE	05.07.13	TITLE	OUTER AFT SADDLE		
				REV. E	SHEET 1 OF 1
				SCALE	2:3

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